








Work Order ID 47002B01

Friday, June 26, 2009 10:46:23 AM




Page 1


Item ID: D3186-2M Accept  Setup Start 
Revision ID: D Stop 
Item Name: SPACEPOD DOOR RH
Start Date: 7/15/2009 Start Qty: 1.00  Cust Item ID:
Required Date: 8/3/2009 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3186	Rev D								

100  PURCHASING 0.00
Purchasing Memo 0.00
Purchasing Issue P/O: 8531 ☐ Description: D3186-2M Door ☐ Supplier:
Delastek ☐ Conformity Certificate and Process sheet required ☐ Ship 3 Items from
Previous steps

110  Receive & Inspect for Damage & Mat'l Certs 0.00
Packaging Memo 0.00
Packaging Ensure a copy of certification of conformity and process sheet from Delastek is
attached.

120  QC6- Inspect dimensions to drawing 0.00
QC Memo 0.00
Quality Control Check for void spot and pins.

=> 80764130

8/27/17

20

Work Order ID 47002B01

Friday, June 26, 2009 10:46:23 AM



Page 2

Item ID: D3186-2M

Accept



Setup Start



Revision ID: D

Stop



Item Name: SPACEPOD DOOR RH

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

Pc 8/7/17 *(1)*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/08 *09-9-04*

Picklist Print

Page 1

Friday, June 26, 2009 10:46:23 AM

Work Order ID: 47002B01

Parent Item: D3186-2MRevD

Parent Item Name: SPACEPOD DOOR RH


Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3186-2PRevD		Purchased	No			100	Each	0.0000	1.0000			
												
Spacepod Door												

D350-600-242

Dart Aerospace Ltd.

Date: Tuesday, 07/04/2009 10:28:27 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD DOOR RH
Job Number : 47002B01	
Estimate Number : 12599	
P.O. Number :	Part Number : D31862M
This Issue : 07/04/2009 S.O. No. :	Drawing Number : D3186 REV.D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 46180B01	Material :
Written By :	Due Date : 10/05/2009 Qty: 1 Um: Each
Checked & Approved By : <u>Julie Dawson</u>	
Comment : Est Rev:A New Issue 06-12-04 ec est rev B rev D dwg 07.03.07 ec	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 ☒ PG

PURCHASING



Comment: PURCHASING

Issue P/O: 8531

Description: D3186-2M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

C209/04/08

①

2.0 ☒

D31862P

Spacepod Door



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Door

3.0 ☒

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from

Delastek is attached.

4.0 ☒

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 . Visual inspection. Check for void spot and pins.

S 09/04/30

5.0 ☒

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:28:27 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 47002B01

Part Number: D31862M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

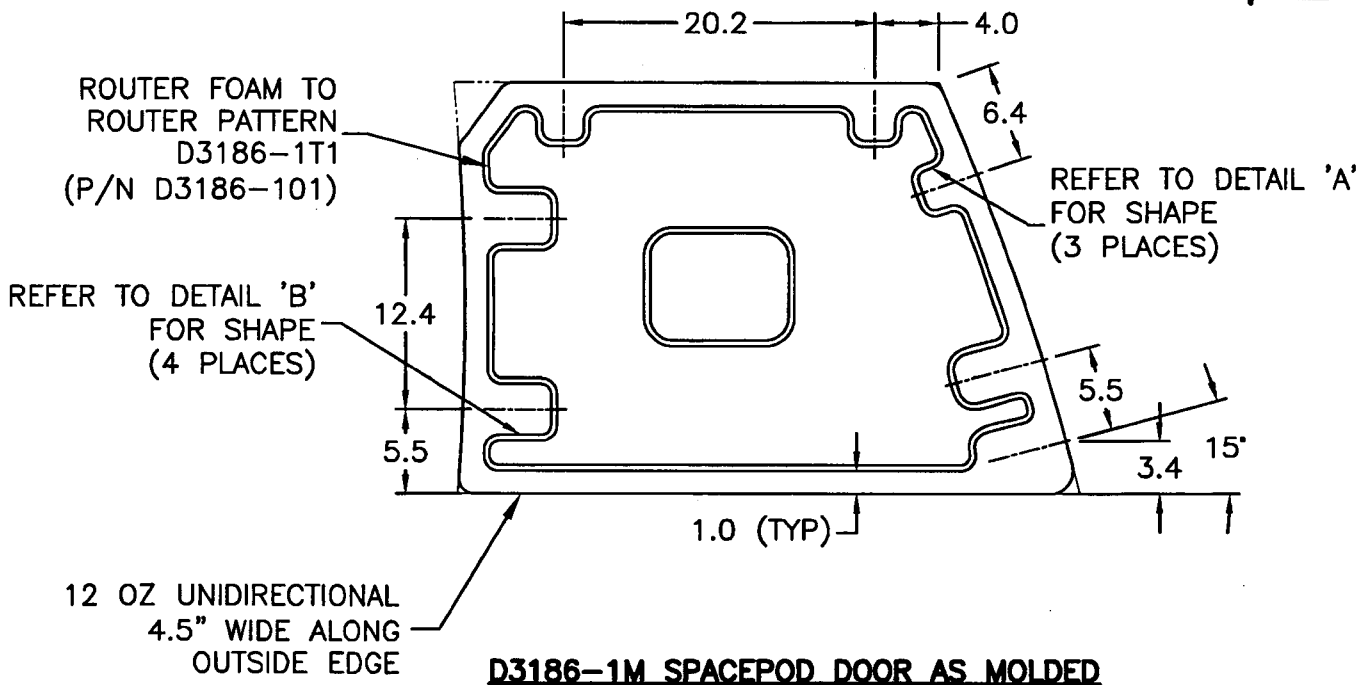
NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED07.02.27 **H****D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

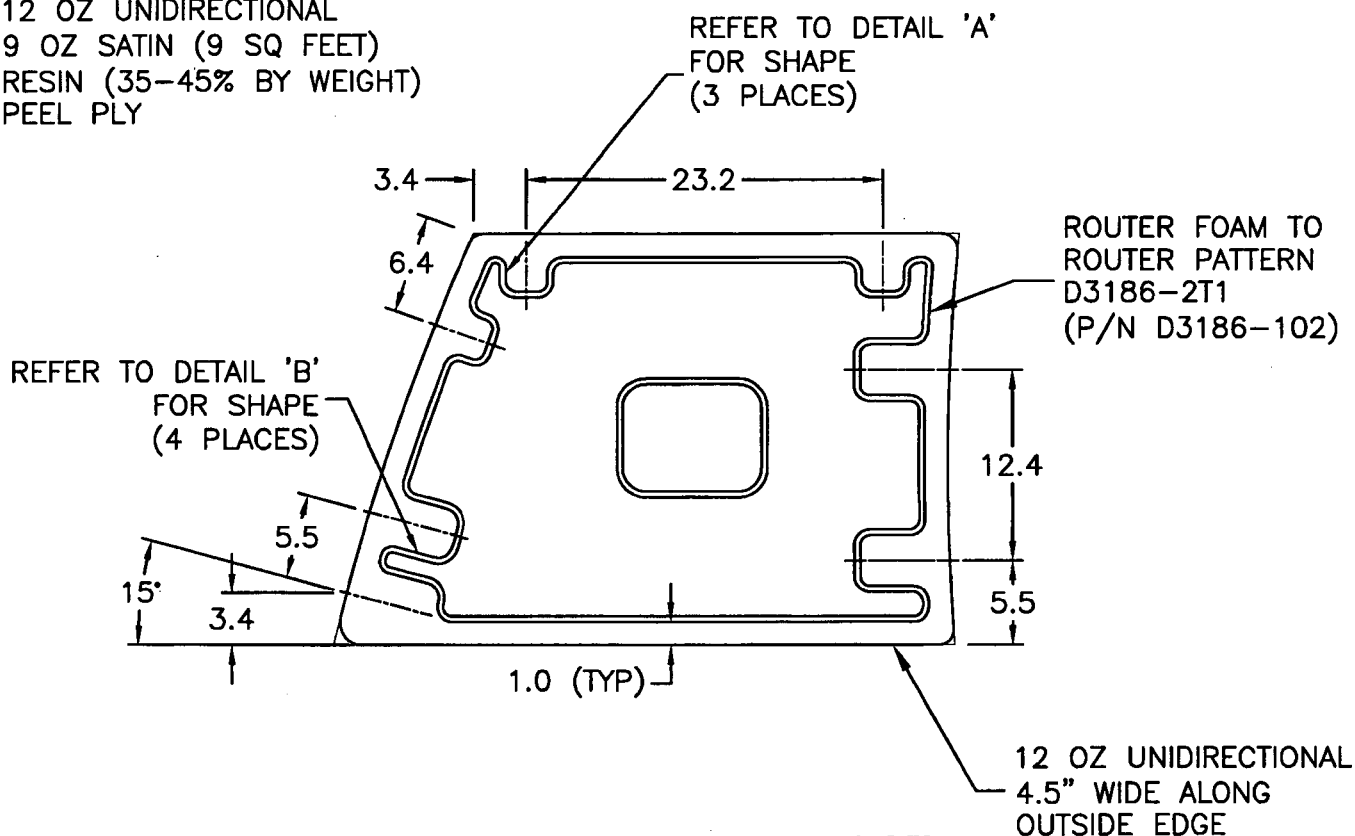
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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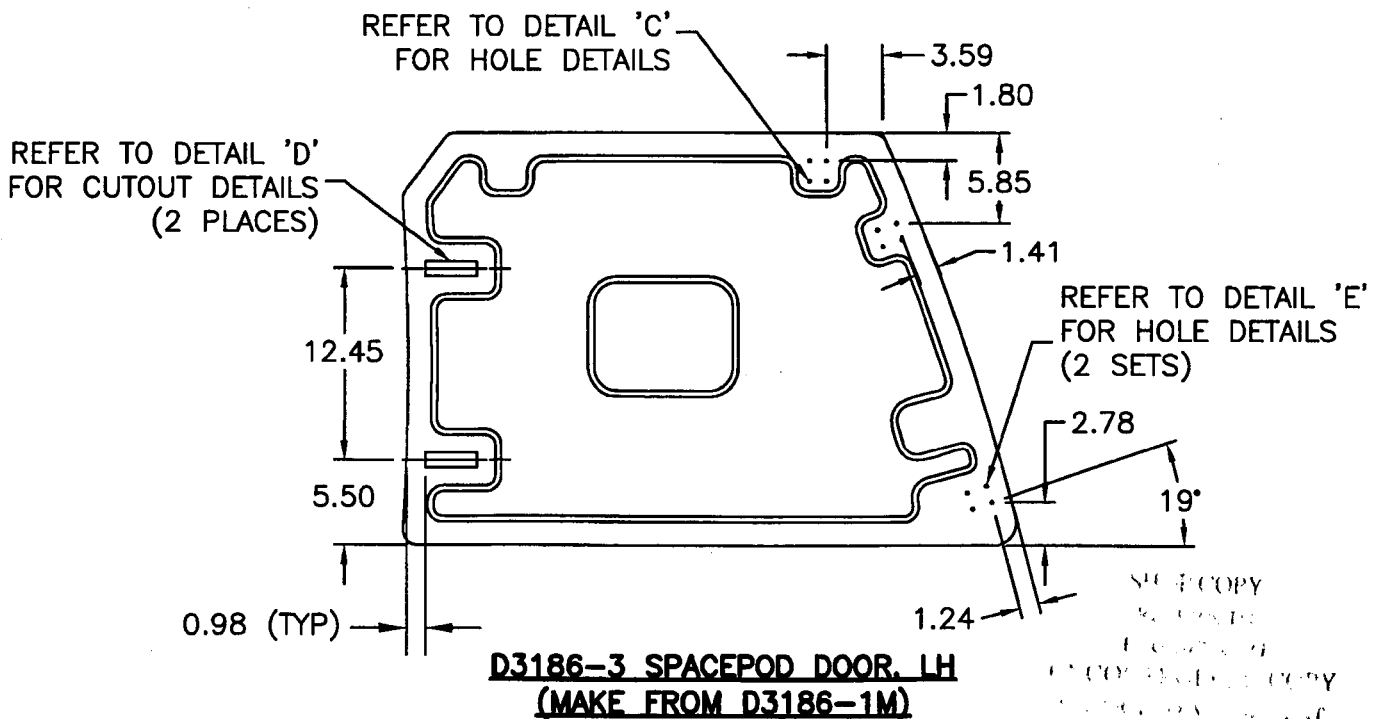
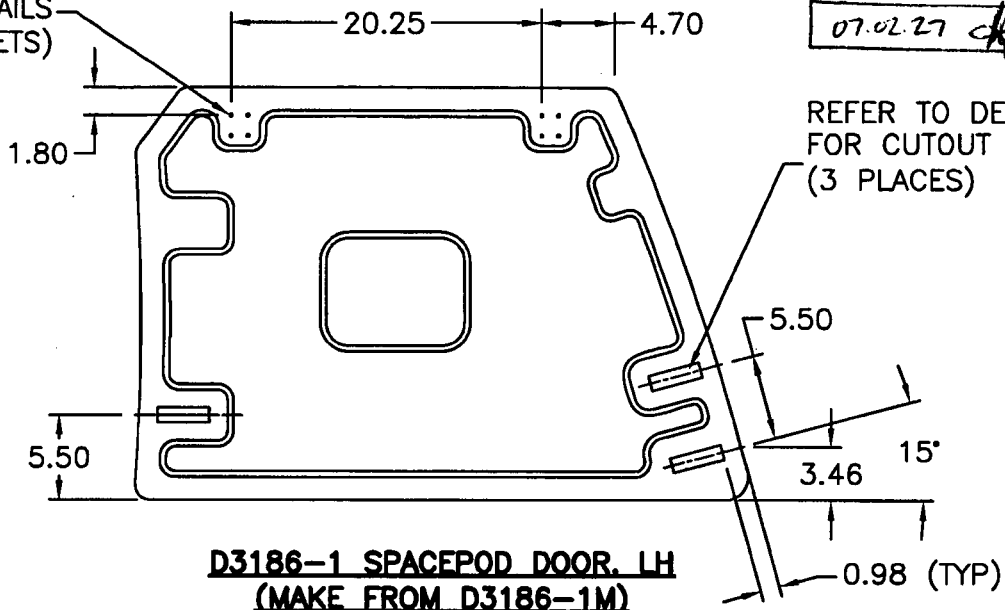
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)



NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

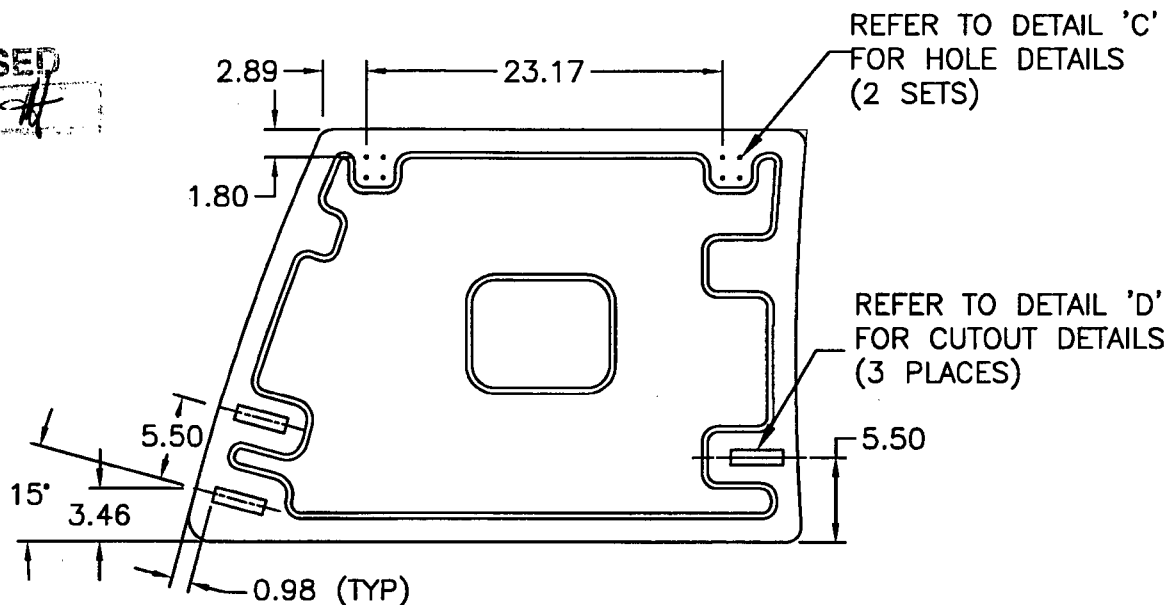
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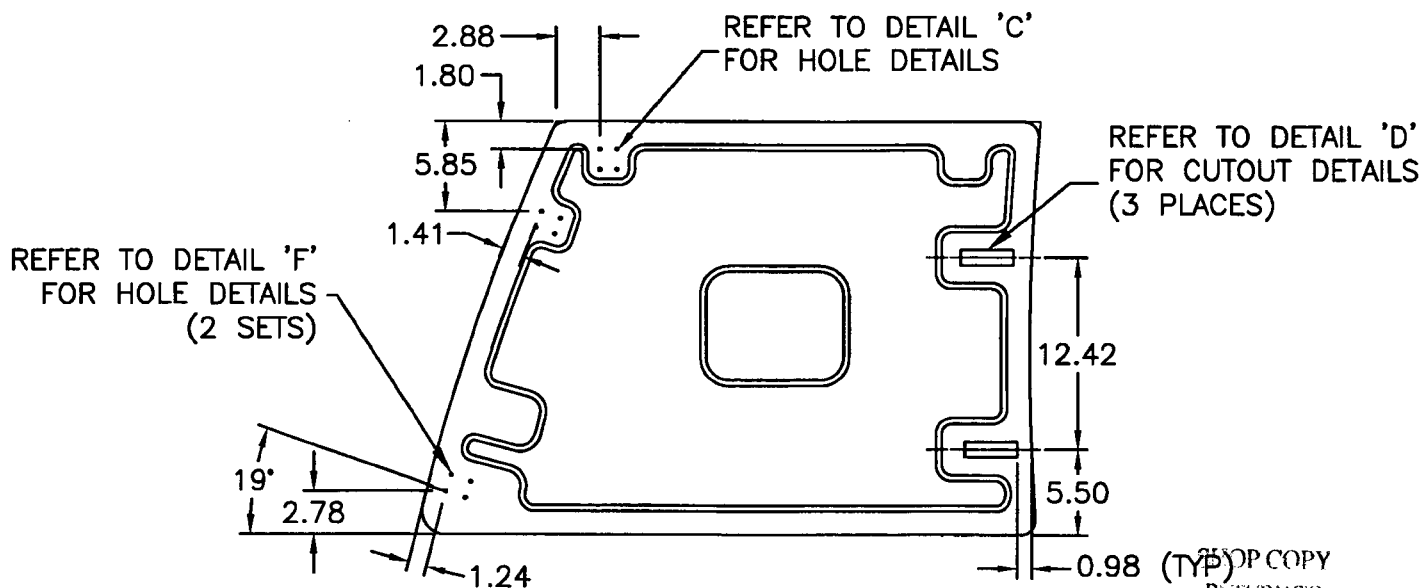


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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED
07-02-27



D3186-2 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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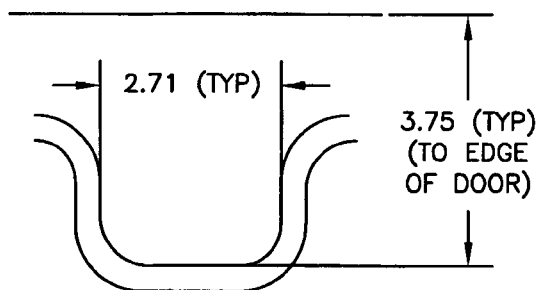
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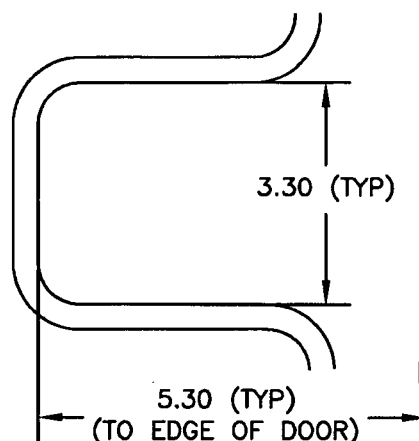
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS



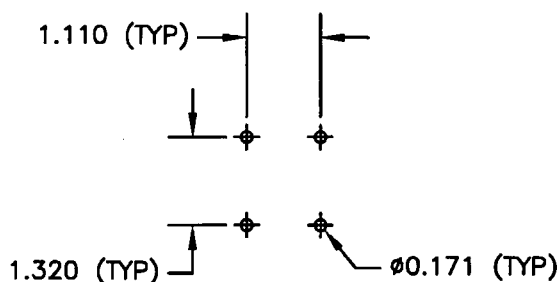
DETAIL A



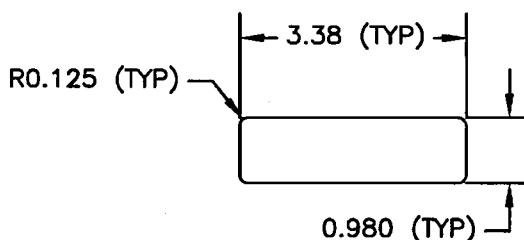
DETAIL B

RELEASED

07.02.22 [Signature]

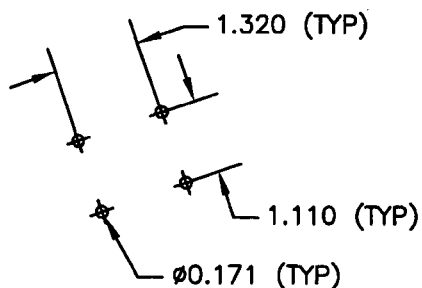


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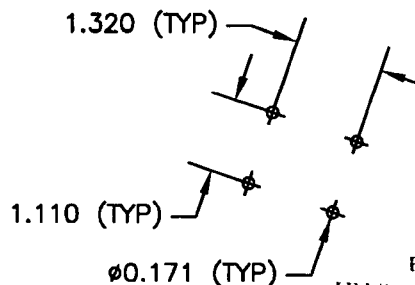


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

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NO. 47002301

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Telephone: (819) 533-5788
Warehouse: MAIN

Invoice #	13202
Customer #	DART

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #	GST/PST #		
16/07/2009	08/04/2009	5990	Chantal Lavoie	PO00006531	8531		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0060	D31862P Spacepod Door RH B47002B01 Dwg. Rév.: D No. lot 43684 U de M : Each Qté 1			
1	0	1	DKC134-0069	D31882P Spacepod Body RH B47002A Dwg. D3188 Rév.: E No. lot 43773. U de M : Each Qté 1			

I hereby certified that all materials, process and finished items were
controlled and tested in accordance with the requirements of the purchase
order and applicable specifications. All such records are on file at our plant
and available for review upon request.

Sust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Client : DART	Dart Aerospace Ltd.	Nom Dessin : SPACEPOD DOOR	
Numéro Job : 43684		Numéro Article : DKC134-0060	
Numéro Soumission : 2610		Numéro Dessin : D3186	
Numéro B.A. :		Projet Numéro : DKC134	
Cette fois : 2009-02-18	No. B.V. :	Révision dessin : D	
Prsht Rev. : NC		Matériel : Fibre 7781 et Résine 411-350	
Prem. fois : - -	Type :	Date Dûe : 2009-02-25	Qté: 1 Udm: UNITE
Job précédente : 43683			



Écrit par : _____
Vérifié & Approuvé par : _____
Commentaires : N° de pièce Dart Aerospace : D31862M

Process Sheet Rév.: 02 Modification du planning afin d'y inclure le
N° I.G 0008 (Primer)

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0303	Frekote 44NC
-----	--------	--------------

Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s)
Frekote 44NC

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: 19/03/09 Heure Début: 2:50 Heure Fin: 3:00 Sceau:



3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)
Tissu à délaminer Release ply B

4.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)
Wrightlon 5200 Bleu P3

5.0	AC0408	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)
Feutre de drainage N° Airweave N 10

6.0	AC0752	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)
Stretchlon 200 poche à vide Vert

Date: Mercredi, 2009-02-18 10:52:41
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43684

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0060

Numéro Job: 

Séq.: Machine ou Opération: Description :

26.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte.

Faire le laminage du dernier pli de 9.7 oz.

Date: 25-3-09 Heure Début: 8:55 Heure Fin: 9:25 Sceau:  

27.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE





Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 25-3-09 Heure Début: 9:25 Heure Fin: 9:35 Sceau:  

Curing Début: 8:55 Curing Fin: 4:00


28.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
DÉMOULAGE DES PIÈCES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le le moule afin d'éliminer le fini lisse de celui-ci.

Date: 26-3-09 Heure Début: 11:00 Heure Fin: 11:05 Sceau: 

ate: Mercredi, 2009-02-18 10:52:41
tilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43684

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0060

Numéro Job:



Séq.: Machine ou Opération: Description :

29.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE DE FINITION

Trimer les contour de la pièce l'aide du gabarit de trimage prévu à cet effet.

Date: 26-3-09 Heure Début: 11:30 Heure Fin: 12:00 Sceau:

30.0 AAC0683 Dupont Primer N° 7704S

Commentair Qty.: 0.1390 UNITE(s)/Unit Total : 0.1390 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-21723-1

31.0 AAC0685 Dupont Activator - Reducer Chromabase N° 7775S

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
Dupont Activator - Reducer Chromabase N° 7775S

32.0 PRIMER APPLICATION DE PRIMER



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
APPLICATION DE PRIMER

Appliquer le primer selon I.G. 0008

Quantité: 1 Date: 03/04/09 Sceau:

Quantité: 1 Date: 06/04/09 Sceau:

Quantité: 1 Date: 10/04/09 Sceau:

Quantité: 1 Date: 14/04/09 Sceau:

33.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
INSPECTION PIÈCE DART





Inspection des pièces par le département de la qualité

Quantité: 1 Date: 15-4-09 Sceau:

Quantité: Date: Sceau:

ate: Mercredi, 2009-02-18 10:52:41
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD DOOR	
Numéro Job: 43684		Numéro Article: DKC134-0060	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
34.0	EMBALLAGE	EMBALLAGE ET ENTREPOSAGE	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs EMBALLAGE ET ENTREPOSAGE			
Faire l'emballage des pièces.			
Quantité: <u>1</u>	Date: <u>15-4-09</u>	Sceau: 	
Quantité: _____	Date: _____	Sceau: _____	